



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

D4931-3

Job Sheet 181982



Part No: D4931-3

Job Qty: 5 ea

Part Name: Engine Fitting (For B3 Models)



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 8/15/18

Job Tracking No:

Due Date: 8/31/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG REV A SHEET 2 IPP REV:A NEW ISSUE 13-09-16 JLM VERIFIED BY:DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	5 Ea	8/31/18	8/31/18	0.00	0.00	Start Up Machining-3		
100	Doosan	5 pcs	8/31/18	8/31/18	0.52	4.95	Doosan		
110	QC	5 pcs	8/31/18	8/31/18	0.00	0.00	QC2 Machining-3		
112	Mill Conv	5 pcs	8/31/18	8/31/18	0.00	1.91	Mill Conv 1		
115	QC	5 pcs	8/31/18	8/31/18	0.00	0.00	QC2 Machining-3		
120	QC	5 pcs	8/31/18	8/31/18	0.00	0.00	QC8 Machining-3		
130	Packaging	5 pcs	8/31/18	8/31/18	0.00	0.00	Packaging3-2		
140	QC21-SA	5 Ea	8/31/18	8/31/18	0.00	0.00	QC21		

Part Op 100 - Machine as per folio FB210
Descriptions: 112 - DRILL HOLES AS PER REQUIRED

DAS
21
9-89

SEP 25 2018

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M303R2.000	303 Round Bar 2"	.7500 ft (.15 ea)	90-Start up Operation	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	M303R2.000	1	36	0

Part Specifications

Specifications could not be found.

DQA: _____ Date: _____

**WORK ORDER NON-CONFORMANCE / UPDATE**

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : _____					

DART AEROSPACE LTD		Work Order: 181982
Description: EAPS P2 Engine Fitting		Part Number: D4931-3
Inspection Dwg: D4931	Rev: A	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
1-1/16-12 UN 2A	Maj: 1.0608 Min: 1.0494	1.050				
M.O.W.	Maj: 1.0995 Min: 1.0938	1.0965				
0.13 x 45°	+/-0.030 x +/-0.5°	0.125 x 45°				
Ø0.063	+0.004/-0.001	0.062				
0.08	+/-0.030	0.075				
0.906	+/-0.010	0.908				
0.13	+/-0.030	0.128				
0.25	+/-0.030	0.255				
0.938	+/-0.010	0.935				
1.927	+/-0.010	1.932				
0.250	+/-0.010	0.249				
0.424	+/-0.010	0.420				
0.315	+/-0.010	0.316				
0.185	+/-0.010	0.187				
37°	+/-0.5°	36.5°				
0.33	+/-0.030	0.33				
34°	+/-0.5°	33.5°				
0.532	+/-0.010	0.527				
1.063	+/-0.010	1.062				
0.594	+/-0.010	0.5945	✓			Version SV05
0.791	+/-0.010	0.787	✓			Version SV05
1.188	+/-0.010	1.189	✓			Version SV05
1.582	+/-0.010	1.5805	✓			Version SV05
0.238	+0.005 -0.001	0.241	✓			Version SV05

Measured by: [Signature]	Audited by:	Preliminary Approval:
Date: 18/09/19	Date:	Date:

Rev	Date	Change	Revised by	Approved
A	14.06.24	New Issue	KJ	[Signature]

DQA: _____ Date: _____

**WORK ORDER NON-CONFORMANCE / UPDATE**

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
				Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ DART AEROSPACE Container No: S111570 Part: D4931-3 Job No: 181982 Serial No/ Batch: S111570 Revision: _____ Inspector: _____ Exp Date: _____ Instructions: Various STC's Roost ☐ Rt ☐ Prc ☐ Proc ☐ Manu ☐ Past D ☐	
Lower Loss/Surge ☐ Mismatch/Program ☐ Mismatch ☐ Mismatched ☐ Missing Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐		Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : _____					